

Work Order ID 79563

79563

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January-27-12 12:53:19 PM

Item ID: D2647 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Cap
 Start Date: 27/01/2012 Start Qty: 60.00 *60* Cust Item ID:
 Required Date: 10/02/2012 Req'd Qty: 60.00 *60* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/01/12 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2647	Rev F

100	FLOW WATER JET	0.00							
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100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D2647
 6061 GDC Dwg Rev: F
 Prog Rev: F
 2-Deburr if necessary

B12-4-12

(90)

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
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110
 QC Memo 0.00
 Quality Control

B12-4-2

120	QC8- Inspect parts - second check	0.00							
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120
 QC Memo 0.00
 Quality Control

8/26/12

cuts
 196

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 Required Date: 10/02/2012 Req'd Qty: 60.00 ***60*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab Small Fab	Small Fab Memo Debur	0.00 0.00	N/A						
140 *140* QC	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
150 *150* Packaging Packaging	Identify as per dwg & Stock Location Memo ***STOCK IN SKIDTUBE CELL***	0.00 0.00							

(Sp)

12-04-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 27/01/2012 **Start Qty:** 60.00

60

Cust Item ID:**Required Date: 10/02/2012 Req'd Qty: 60.00**

60

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID

Tool

Plan Code

Accept Qty

Reject Qty

Reject Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

Qty Number Stamp
12/4/17 *[Signature]*
mr
12-04-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 79563

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Parent Item: D2647

D2647

Parent Item Name: Cap

Start Date: 27/01/2012

Required Date: 10/02/2012

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP Rev:D99.01.25Re-formatDM
IPP: E 06.11.15 waterjet

EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.080

Purchased

No

100

sf

390.3000

0.1597

10.08632

16,

M6061T6S 080

**

B 12-4-2

6061-T6.080 Sheet

Location

Loc Qty

Loc Code

MAT021

390.3

117285

7.3

119009

3.5

119766

187.5

120349

192

121096

96

W/O:		WORK ORDER CHANGES					
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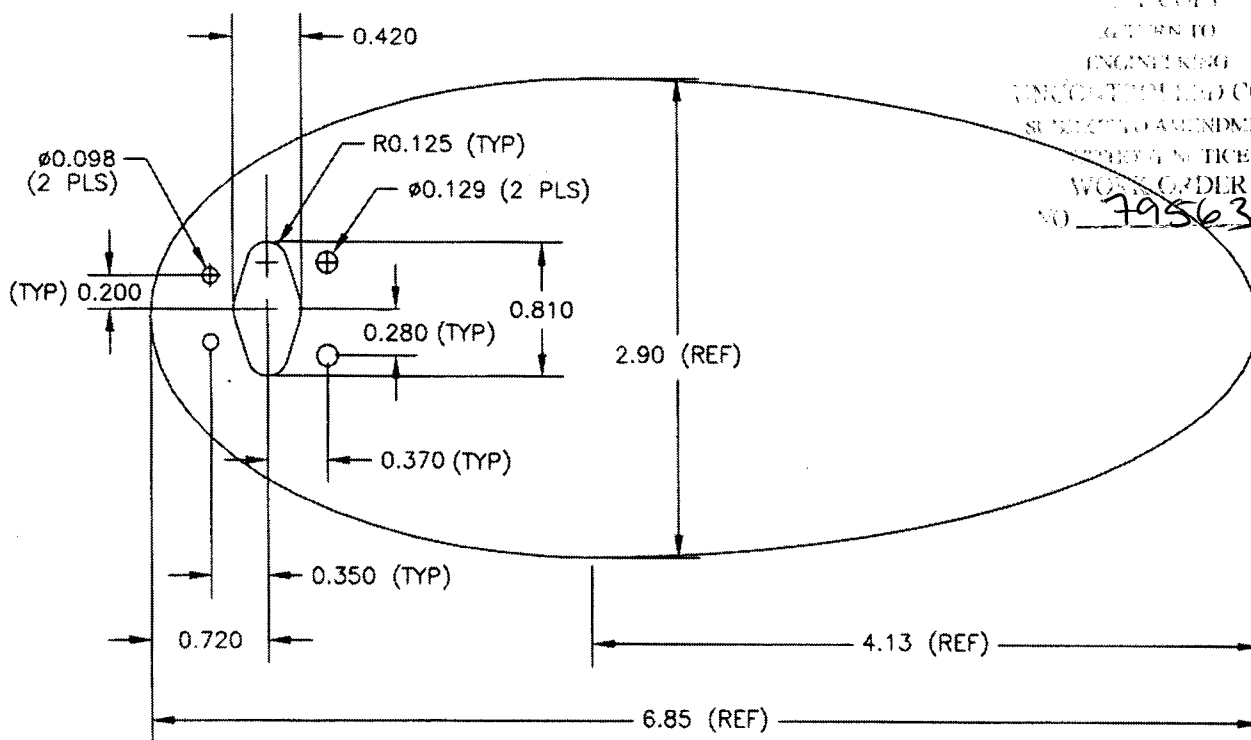
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DESIGN #	DRAWN BY RT	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED #	APPROVED #	DRAWING NO. D2647	REV. F SHEET 1 OF 1
DATE 00.05.26		TITLE CAP	SCALE NTS
A	97.03.25	NEW ISSUE	
B	97.06.27	CHANGED SHAPE	
C	97.09.15	REMOVE FRONT PLATE	
D	97.11.06	ADD RIVET HOLES	
E	98.01.15	ADD 5052 MATERIAL (TSR A245)	
F	00.05.26	MAKE FROM D2794	

RELEASED
00 06.07 97



THIS PART CAN BE MADE FROM D2794

MATERIAL: 6061-T6 (QQ-A-250/11) OR
5052-H32 (QQ-A-250/8) 0.080 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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